Dart Aerospace Ltd.

Date: Wednesday, 1/31/2007 2:39:28 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 30521		
Estimate Number	: 10274		
P.O. Number	: N/A	Part Number	: D350591312
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Number	: D3272 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 30463	Material	: N/A
Written By	:	Due Date	: 3/15/2007 Qty: 10 Um: Each
Checked & Approved By	: 07.02.01		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL

Comment: DOCUMENT CONTROL
Photocopy bluefile and type labels as per PPP D350-591-311 CHG001 KJ 07.02.15

Seq. #:	Machine Or Operation:	Description :
2.0	D2622120C	Extrusion

Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2622-120	Extrusion	B29607

FF 07-03-28 10

Seq. #:	Machine Or Operation:	Description :
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A FF 07-03-28 10

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. FF 07.03.28 10

3-Deburr FF 07-03-28 10

Seq. #:	Machine Or Operation:	Description :
4.0	QC5	INSPECT WORK TO CURRENT STEP

07.04.02

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
5.0	D30671	End Plate

Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3067-1	End Plate	33043

07.04.02 10

Form: process

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services   **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30521   **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D32191	Support

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick:
Qty Part Number Description Batch
2 D3219-1 Support B30468   07.04.02 10

Seq. #:	Machine Or Operation:	Description :
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY   07.04.02 10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272   07.04.03 10
A/R Aluminum Rod M100237
M102225

3-Grind End Plate flush   07.04.03 10

Seq. #:	Machine Or Operation:	Description :
8.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION   07/04/03 (10)

Seq. #:	Machine Or Operation:	Description :
9.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP   07/04/03 (10)

Seq. #:	Machine Or Operation:	Description :
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

(10X)

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1   M.R   07/04/04

Seq. #:	Machine Or Operation:	Description :
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION   FF 07/04/04 10

Seq. #:	Machine Or Operation:	Description :
12.0	D3065041	Step Leg Assembly

Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)
Pick:
Qty Part Number Description Batch
1 D3065-041 Step Leg Assy B29978   FF 07-04-04 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:39:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30521
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
13.0	D30661	Spacer

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3066-1	Spacer	B30467

FF 07-04-04 10

Seq. #:	Machine Or Operation:	Description :
14.0	MS20600AD4W4	Rivets

Comment: Qty.: 16 Each(s)/Unit Total : 160 Each(s)
Pick:

Qty	Part Number	Description	Batch
16	MS20600AD4W4	Rivet	M102850

FF 07-04-04 10

Seq. #:	Machine Or Operation:	Description :
15.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Assemble Leg Assembly as per Dwg D3272.

FF 07-04-04 10

Seq. #:	Machine Or Operation:	Description :
16.0	QC5	INSPECT WORK TO CURRENT STEP

07.04.05 (10)

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
17.0	D30671	End Plate

Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3067-1	End Plate	B30143

07.04.11 10

Seq. #:	Machine Or Operation:	Description :
18.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding — 07.04.11 10

2-Inspect for foreign object as per QSI 024 — 07.04.11 10

3-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod M100237 — 07.04.11 10

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 1/31/2007 2:39:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30521

Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
	4-Grind End Plate flush	07-04-12 10
19.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	07/04/12 (10)
20.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/04/12 (10)
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Touch up Alodine	07-04-16 (10)
22.0	POWDER COATING	POWDER COATING
	M 103607	
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	07-04-17 (10)
23.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	M103707	
	Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3272 and QSI 005 4.4	07/04/17 (10)
24.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		07-04-19 (10)
	Comment: Inspect Powder Coat and Wing Walk	
25.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
26.0	D22303	Mounting Lug
	Comment: Qty.: 4 Each(s)/Unit Total : 40 Each(s) Pick: Packing Kit Qty Part Number Description Batch ✓ 4 D2230-3 Mounting Lug ~~B30273~~ B30273 ✓	07/04/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 1/31/2007 2:39:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30521 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
27.0	D2618	Bushing

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2618 Bushing B29645

Seq. #:	Machine Or Operation:	Description :
28.0	D2856400	Abrasion Strip

Comment: Qty.: 1 f(s)/Unit Total : 6 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2856-400-720 Abrasion Strip B29850

Seq. #:	Machine Or Operation:	Description :
29.0	D32351	Mounting Lug

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D3235-1 Mounting Lug B30050

Seq. #:	Machine Or Operation:	Description :
30.0	D3278041	Support Assembly

Comment: Qty.: 1 Each(s)/Unit Total : 10 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D3278-041 Support Assembly B29647

Seq. #:	Machine Or Operation:	Description :
31.0	AN335A	Bolt

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN3-35A Bolt M102339

Seq. #:	Machine Or Operation:	Description :
32.0	AN413A	Bolt

Comment: Qty.: 8 Each(s)/Unit Total : 80 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M103363

07/04/18 (10)

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:39:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30521
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
33.0	AN536A	Bolt

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN5-36A Bolt M103481 (5X) M104093 (15X)

Seq. #:	Machine Or Operation:	Description :
34.0	AN960JD10	Washer

Comment: Qty.: 4 Each(s)/Unit Total : 40 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD10 Washer M103962

Seq. #:	Machine Or Operation:	Description :
35.0	AN960JD416	Washer

Comment: Qty.: 16 Each(s)/Unit Total : 160 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
16 AN960JD416 Washer M102929

Seq. #:	Machine Or Operation:	Description :
36.0	AN960JD516	Washer

Comment: Qty.: 4 Each(s)/Unit Total : 40 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD516 Washer M102519

Seq. #:	Machine Or Operation:	Description :
37.0	MS21042L3	Nut

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L3 Nut (or -3) M102658

04/18/10

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:39:29 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 30521

Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
38.0	MS21042L4	Nut

Comment: Qty.: 8 Each(s)/Unit Total : 80 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) 7103914

Seq. #:	Machine Or Operation:	Description :
39.0	MS21042L5	Nut

Comment: Qty.: 2 Each(s)/Unit Total : 20 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L5 Nut (or -5) 7102536 7/04/18 (10)

Seq. #:	Machine Or Operation:	Description :
40.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 07/4/19 (10)

Seq. #:	Machine Or Operation:	Description :
41.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-591-311 7/4/20 (1)
Location: REV: B 7/4/19 (9) QTC

Seq. #:	Machine Or Operation:	Description :
42.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE (10) 07/04/23

Job Completion

4 07.04.23

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/04/23

QA: N/C Closed: ______ **Date:** ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07.04.19	41.0	the step was accidently droped, and mild damage on the aft side of step. One tiny knick, and a scratch.	[signature] QS1042	Buff out mark & touch-up with Alodine. Touch-up affected area with Powder coat as neccesary in accordance with QS1005.	[signature] 07-04-19	[signature] 07.04.20	[signature] QS1042	[signature] 07.04.19

NOTE: Date & initial all entries

DART

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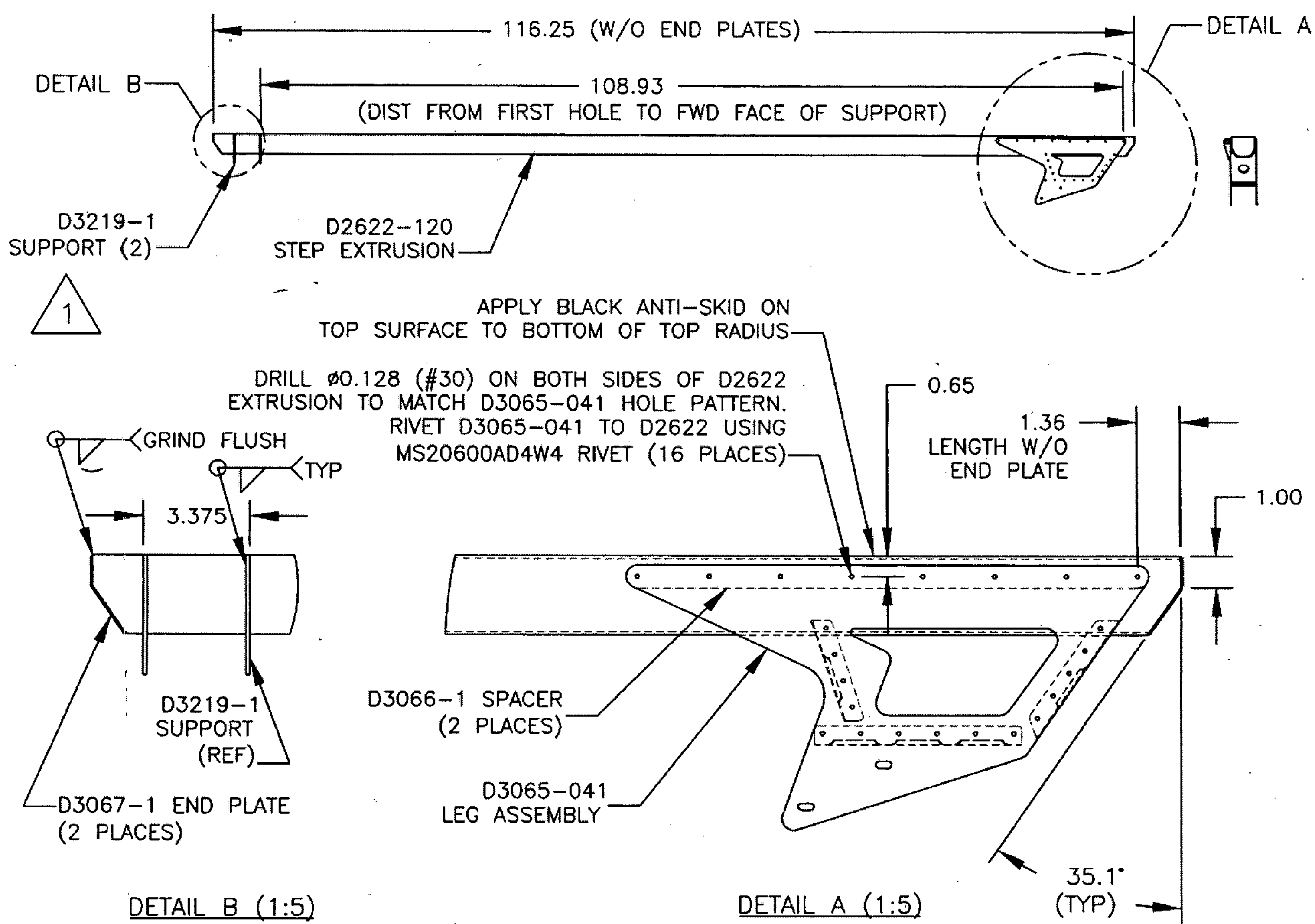
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3272	REV. A SHEET 1 OF 2
DATE 04.03.01		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	

RELEASED 04.04.05

Part No:	Description	QTY -041	QTY -042
D3272-041	**Step Assembly, High/Long (LH)**	**X**	
D3272-042	**Step Assembly, High Long (RH)**		**X**
D2622-120	STEP EXTRUSION	1	1
D3219-1	SUPPORT	2	2
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

1) –041 SHOWN, FOR –042 INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN | DRAWN BY
CHECKED | APPROVED
DRAWING NO. D3272
REV. A
SHEET 2 OF 2
TITLE: STEP ASSEMBLY, HI LONG
DATE: 04.03.01
SCALE: 1:20

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